

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015885**Date Inspected:** 27-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG COMPONENT				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as segment 11CE weld joints.

The welds designation reviewed are as follows:

SEG070*-029,030,019,020,021,022,026,010,009

SEG070A-004,007

SEG070B-004,005,006,020,025,026

SSD19A-PP102-002,003,007

CSD7-PP102-019

CSD6-PP102-087,091

SSD19-PP102-002,009,131,132,138,135

SSD20-PP103-002,009,131,132,135,202,108,253,257

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG)

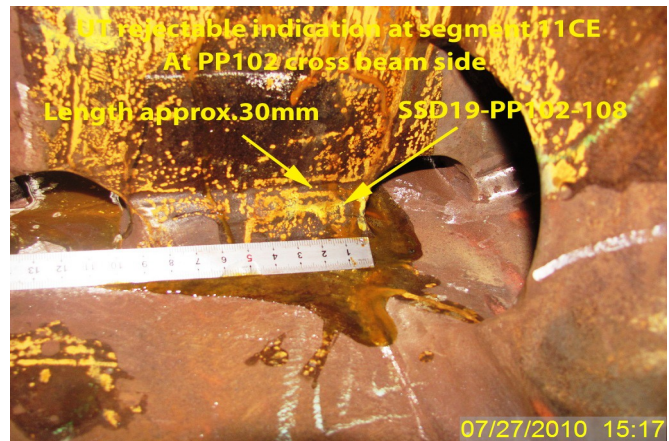
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segment 11CE, this Quality Assurance Inspector (QA) discovered the following issues that total Six(6) longitudinal linear class “A” rejectable indications measuring approximately 15mm~45mm in length. The welds are identified as SEG070*-023,024,025,028,029 and SSD19-PP102-108. Material thickness for joints SEG070*-023,024,025,028,029 is 14mm . Material thickness for joint SSD19-PP102-108 is 30mm. The indication dbz rating for joints SEG070*-023,024,025,028,029 is a +7 to +9. The indication dbz rating for joint for joint SSD19-PP102-10 is +3. The depth of the indications are approximately 7mm~21mm. The welds SEG070*-023, 024,025 are at panel point PP102 and SEG070*-028,029 are at PP101, joining between Deck Plate Diaphragm(X1G) to Deck Plate Diaphragm(X1G). The weld SSD19-PP102-108 is at panel point PP102 joining between bottom Plate BP118A to Floor beam FB13A at Crossbeam side. The welds SEG070*-023,024,025,028, 029 are Complete Joint Penetration (CJP) butt joints. And the weld SSD19-PP102-108 is Complete Joint Penetration (CJP) “T” joint. The Y distance for joint SEG070*-027 is “0” mm from floor beam flange. The Y distance for joint SEG070*-028 is “0” mm from top cope hole. The Y distance for joint SEG070*-023 are 130mm and 240mm from top cope hole. The Y distance for joint SEG070*-024 is 10mm from top cope hole. The Y distance for joint SEG070*-025 is 5mm from top cope hole. The Y distance for joint SSD19-PP102-108 is 5mm from top cope hole. These welds are designated as Non Seismic Performance Critical Members (Non SPCM). The indications are clearly marked on or near the weld. Segment 11CE is located at Front side of Blast Shop. The Notice of Witness Inspection (NWIT) No. is 006285. The indication for joint SSD19-PP102-108 is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel and remaining joints SEG070*-023,024,025,028,029 are located outside of the tested area, by ZPMC Quality Control (QC) personnel.

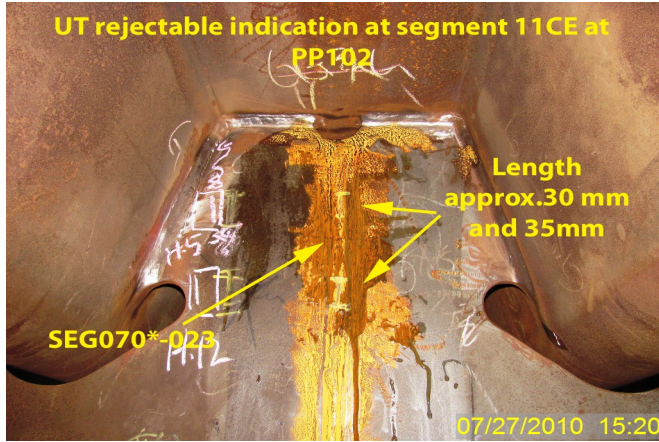
The QA Inspector generated an incident report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera, Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
